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**(54) MOLDING METHOD  
FOR BLOW-MOLDING  
PRODUCT AND DEVICE  
THEREOF**

(57) Abstract:

**PURPOSE:** To prevent foamed cell in a parison from being crashed, by a method wherein, after a cylindrical parison is placed in cavities made of a porous material which is connected to a vacuum suction port of a mold, a vacuum suction in the cavities is performed.

**CONSTITUTION:** A cylindrical parison 9, which is extruded from an extruder and in a molten condition, is clamped at both molds 11 and 11', and is placed in cavities 12 and 12'. With a vacuum pump, connected to a vacuum suction ports 21 and 21', actuated, a vacuum suction in the cavities 12 and 12' is performed through the application of a 76mmHg pressure difference. The surfaces of the cavities 12 and 12' is made of a porous material which is connected to the vacuum suction ports 21 and 21' through air chambers 20 and 20', respectively, whereby the parison is sucked to the surfaces of the cavities 12 and 12', and is formed in the shapes of the cavities. Simultaneously, a cooling air blown in is sucked in through a suction port 31 to cool the inside of the parison 9.

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